

Date: Wednesday, 15/10/2008 3:29:51 PM
 User: Melanie Fauteux

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	UPPER DOUBLER
Job Number	42611			
Estimate Number	12809			
P.O. Number			Part Number	D36083
This Issue	15/10/2008	S.O. No.	Drawing Number	D3608 PRELIM
Prsh Rev.	NC		Project Number	N/A
First Issue	/ /	Type	Drawing Revision	PRELIM
Previous Run	31511		Material	:
Written By			Due Date	22/10/2008
Checked & Approved By	<u>MNF 08-10-15</u>		Qty:	2 Um: Each
Comment	Est Rev:A New Issue 07-03-26 JLM Est Rev:B 08-10-15 preliminary issue DD verified by:EC			

Additional Product

Job Number:



08.12.15

SCRAP



*See
DAVID S. 1504-10-20*

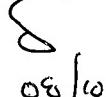
~~PRELIMINARY ISSUE~~

Seq. #:	Machine Or Operation:	Description :
1.0	M304S22GA	304/316 .032 Sheet
		Comment: Qty.: 0.7762 sf(s)/Unit Total : 1.5523 sf(s) 304/316 .032 Sheet Batch: 109087 HB 8-10-16 <i>MNF / cert neg' (Chnbl)</i>
2.0	WATER JET 109087	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3608 Dwg Rev: <u>PRE</u> Prog Rev: <u>Liu</u> HB 8-10-16
		2-Deburr if necessary HB 8-10-16
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		HB 8-10-16
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK
5.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE 1- deburr if necessary 2- Bend as per Dwg D3608
		HB 8-10-16
		① ② ③ ④
		ONE SCRAP - Part Scrapped CP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/10/17	H S.O.	one part scrap. Dan Stew bent in wrong direction R.L. He got distracted	 08/10/17	Scrap and Destroy No replace Qty (4)	 08/10/17	 08/10/17	 08/10/17	 08/10/17

NOTE: Date & initial all entries

Date: Wednesday, 15/10/2008 3:29:51 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UPPER DOUBLER

Job Number: 42611

Part Number: D36083

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



8 06010117 26

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

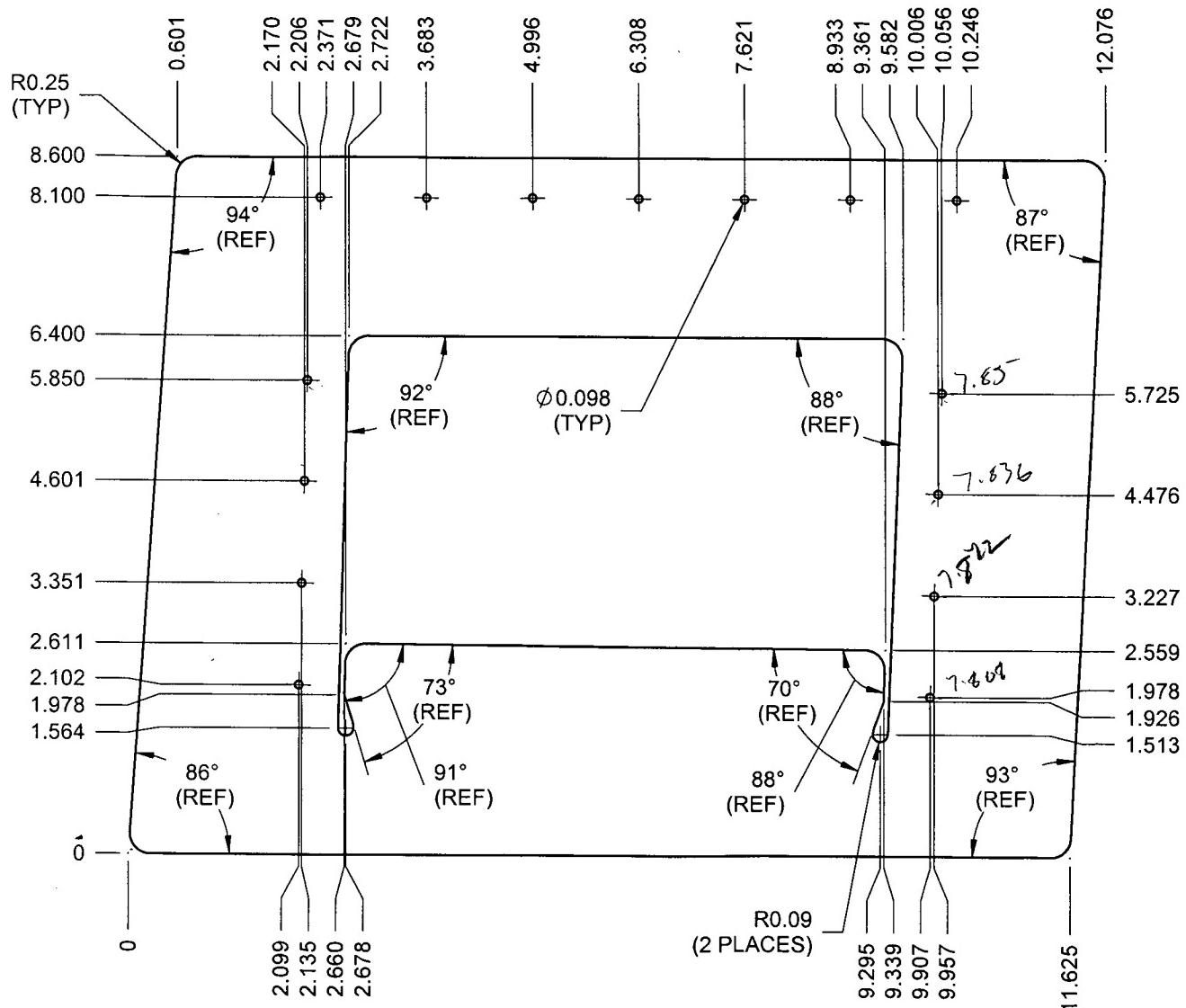
Job Completion



POSITIVE RECALL

EFFECT 08/10/16 AUTH CL
RELEASE DATE _____

DESIGN <i>BS</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED	DRAWING NO. D3608	REV. A SHEET 3 OF 3
DATE 07.04.11	TITLE DOUBLER	SCALE 1:2	



D3608-3F UPPER DOUBLER

PRELIMINARY ISSUE

*MP
08/10/15*

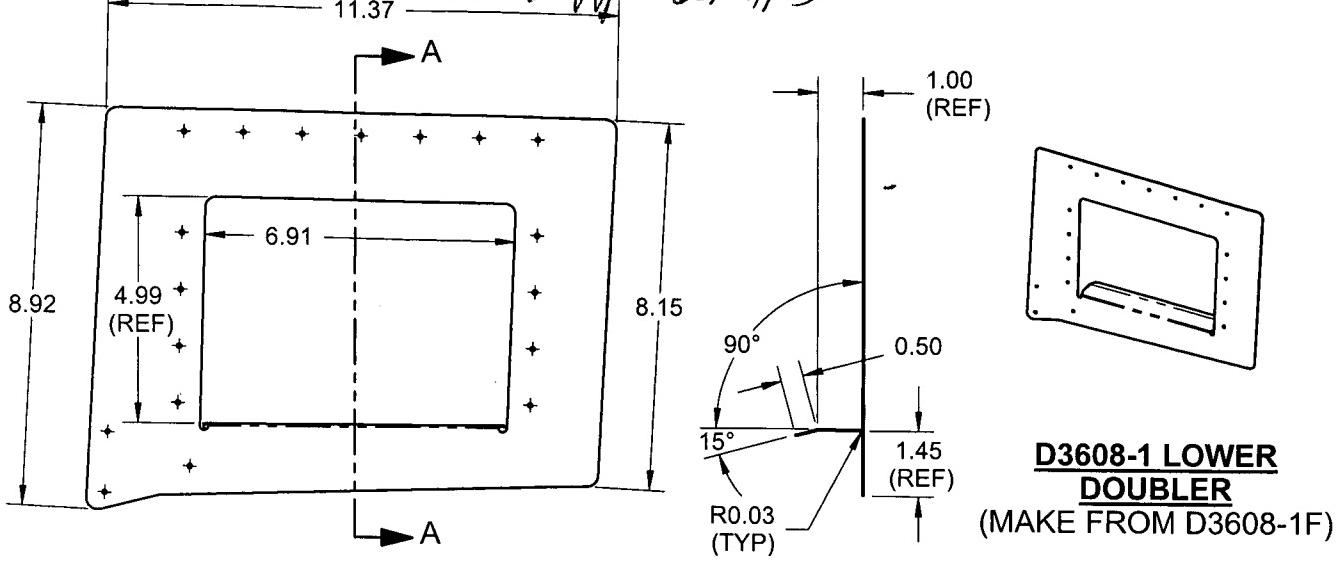
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 22 GAUGE
PER AMS 5513 OR AMS 5524 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

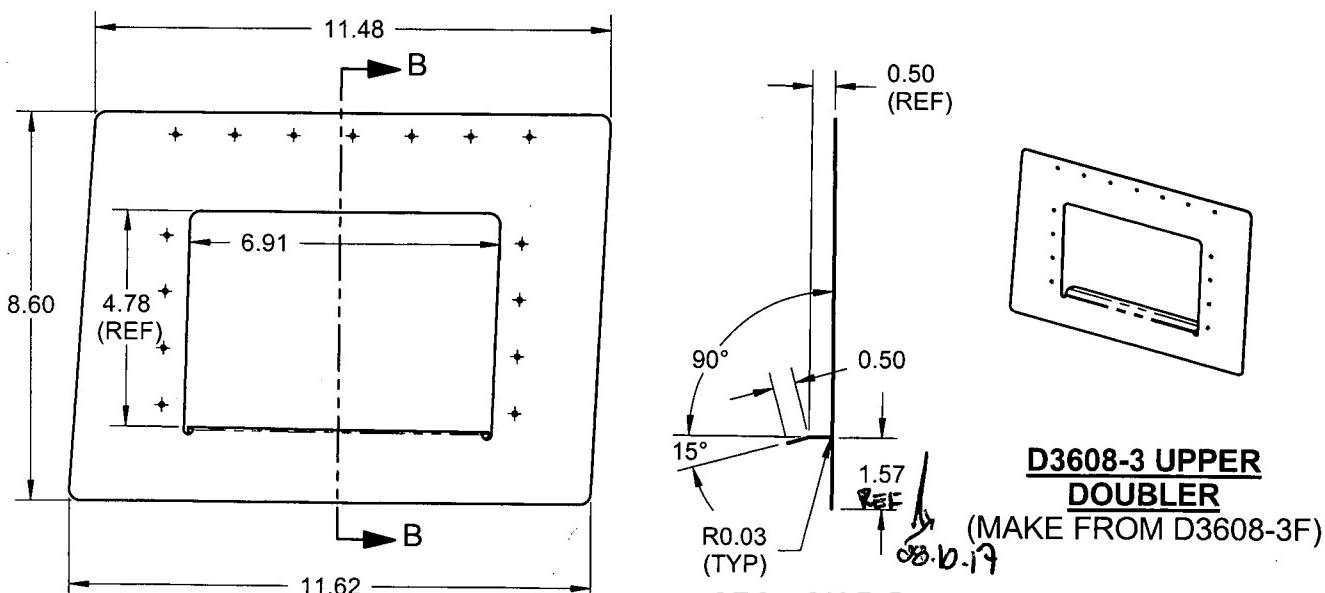
DESIGN <i>BS</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED	DRAWING NO. D3608	REV. A	SHEET 1 OF 3
DATE 07.04.11		TITLE DOUBLER	SCALE	1:4
REV A	DATE 07.04.11	DESCRIPTION NEW ISSUE		

PRELIMINARY ISSUE

MP 08/19/15



SECTION A-A



SECTION B-B

NOTES:

- 1) FINISH: NONE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH DART P/N D3608-1 OR D3608-3 USING FINE POINT PERMANENT INK MARKER
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-775

Job #: 00264

Date: 08.10.15

Product Name: PROTECTIVE TRIMS

Requested By: DS

Design Manager Approval: _____

Quantity	Part Number	Category	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
2	D3608-1F	WJ	LOWER DOUBLER (FLAT PATTERN)	08.10.15	YES*		REQUIRED FOR FIT, FORM AND FUNCTION.*	
2	D3608-1F	GA	LOWER DOUBLER	08.10.15	PER -1F ABOVE		REQUIRED FOR FIT, FORM AND FUNCTION.*	
2	D3608-3F	WJ	UPPER DOUBLER (FLAT PATTERN)	08.10.15	YES*		REQUIRED FOR FIT, FORM AND FUNCTION.*	
2	D3608-3F	GA	UPPER DOUBLER	08.10.15	PER -3F ABOVE		REQUIRED FOR FIT, FORM AND FUNCTION.*	
							CONFORMITY IS MANDATORY.	

DART AEROSPACE LTD

Work Order: 42611

Description: Upper Dowel

Part Number: D3608-3

Inspection Dwg: D3608-3, Rev: Prelim

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
∅ .098	+ .004 - .001	.101	✗			
2.102	+/- .010	2.101	✗			
2.611	+/- .610	2.612	✗			
3.351	+/- .010	3.356	✗			
4.601	+/- .010	4.606	✗			
5.850	+/- .016	5.852	✗			
6.406	+/- .010	6.408	✗			
8.106	+/- .010	8.106	✗			
8.606	+/- .010	8.606	✗			
1.978	+/- .010	1.979	✗			
3.227	+/- .010	3.229	✗			
4.476	+/- .010	4.480	✗			
5.725	+/- .010	5.730	✗			
2.094	+/- .010	2.094	✗			
2.135	+/- .010	2.130	✗			
9.907	+/- .010	9.907	✗			
9.957	+/- .010	9.957	✗			
11.625	+/- .010	11.625	✗			
.601	+/- .010	.609	✗			
2.170	+/- .010	2.165	✗			
2.206	+/- .010	2.201	✗			
2.371	+/- .010	2.368	✗			
3.683	+/- .010	3.680	✗			

Measured by:	RB
Date:	8-10-16

Audited by:	
Date:	08.10.16

Prototype Approval:	
Date:	08/10/17

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order:	47611
Description: UPPPER DOUBLED	Part Number:	D3608-3
Inspection Dwg: D3608-3, Rev: PRELIM		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	LB	Audited by:	JK	Prototype Approval:	MP
Date:	8-10-16	Date:	08.10.17	Date:	08/10/17

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	